



Dart Hawkesbury
1270 Aberdeen St
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Canada

Tel (613) 632-5200

D4379-5

Job Sheet 168138



Part No: D4379-5

Job Qty: 100 ea

Part Name: Wearplate Cup



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/10/17

Job Tracking No:

Due Date: 11/17/17

Created By: Mario Poulin

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	100 Ea		11/16/17	0.00	0.00	Start Up Machining		JL 17-11-23
100	Doosan	100 pcs		11/17/17	0.02	12.94	Doosan		JL 17-11-23
120	QC	100 pcs		11/17/17	0.00	0.00	QC8		17-11-23
130	Packaging	100 pcs		11/17/17	0.00	0.00	Packaging3		17-11-23
140	QC21-SA	100 Ea		11/17/17	0.00	0.00	QC21		

Part Op 100 - turn as per Dwg and folio FB300
Descriptions: 130 - LOCATION: WA001

DAS
21
9-89

NOV 24 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304R1.000	4	1	0	0

5012410

4.93

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate Cup	0.875Inches + 0.000 - 0.005	0.875 0.870	Diameter	
2	Wearplate Cup	0.266Inches + 0.006 - 0.001	0.272 0.265	Diameter	
3	Wearplate Cup	0.466Inches ± 0.010	0.476 0.456		
4	Wearplate Cup	0.353Inches ± 0.010	0.363 0.343		
5	Wearplate Cup	0.031Inches ± 0.010	0.041 0.021		
6	Wearplate Cup	45.000Degrees ± 0.500	45.500 44.500	Angle	
7	Wearplate Cup	0.200Inches ± 0.010	0.210 0.190		
8	Wearplate Cup	0.507Inches ± 0.010	0.517 0.497		

Plex 11/10/17 7:54 AM dart.poulin.mario

POSITIVE RECALL

EFFECT: 17-11-23 AUTH: [Signature]

RELEASED: _____ DATE: _____

m21/carts

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval _____
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor
		Approval Verification

Job No: 168138
Mfg Date: 11/23/17

Start up Operation

Change No: _____

Operation: _____

Revision: _____

PART NO: _____

D4379-5

Wearplate Cup



S013051



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Root Cause		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐
Design ☐	Operator ☐	Bending ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/v ☐
Material ☐	Use for Testing ☐	Cuffs ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐
Past Expiry Date ☐	Manufacturing Process ☐	
Misidentified ☐	Past Due ☐	OTHER : _____

